Fig.1

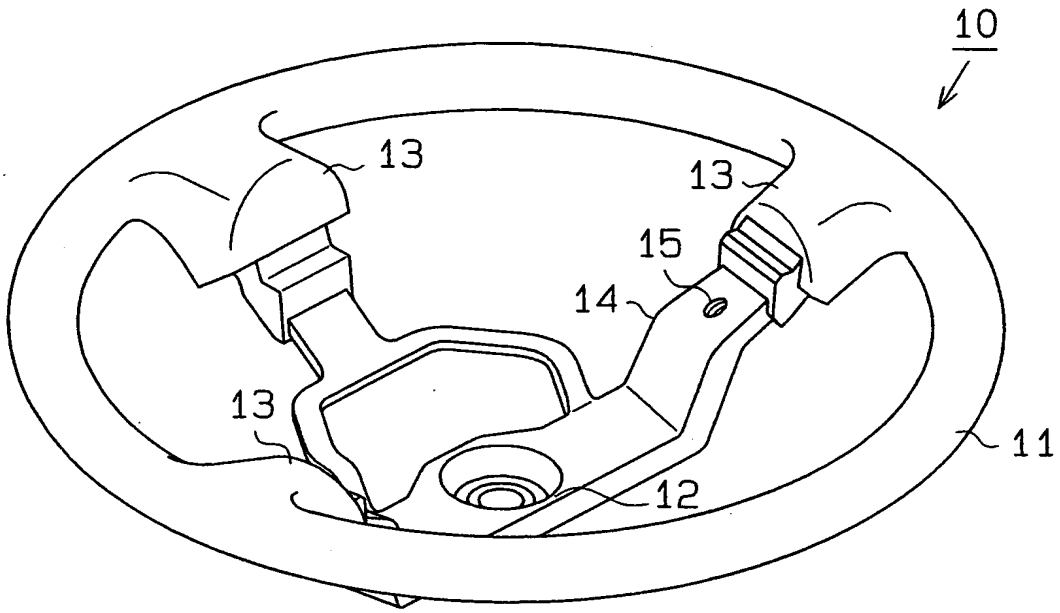

10
13
13
15
14
13
11
12

Fig.2

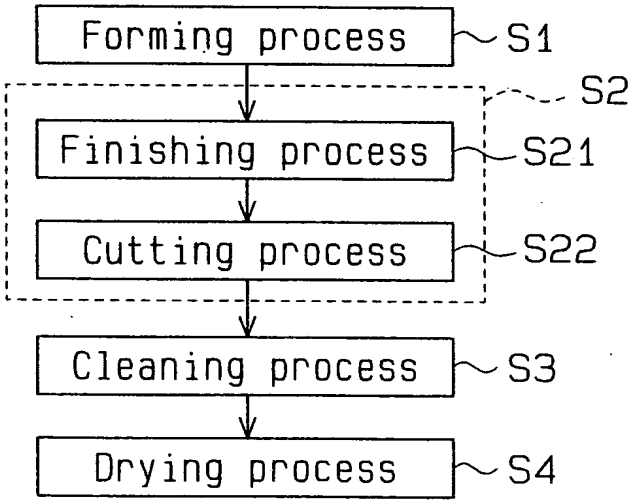

Forming process
S1
S2
Finishing process
S21
Cutting process
S22
Cleaning process
S3
Drying process
S4

Fig.3

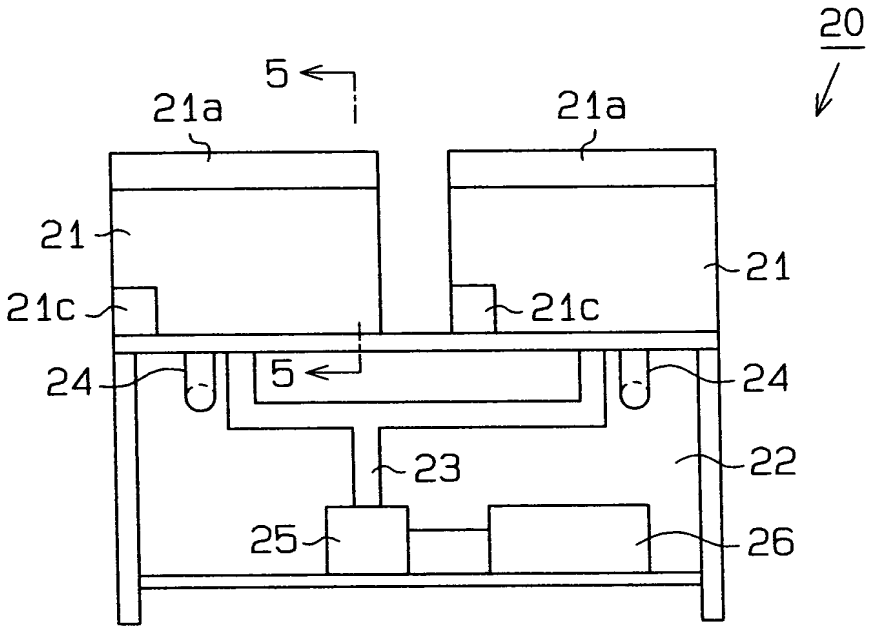

20
5
21a
21a
21
21
21c
21c
24
5
24
23
22
25
26

Fig.4

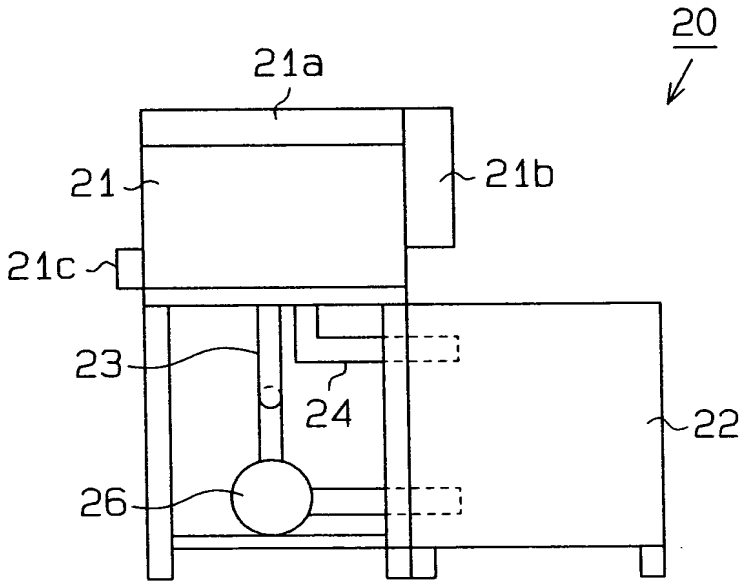

20
21a
21
21b
21c
23
24
22
26

Fig.5

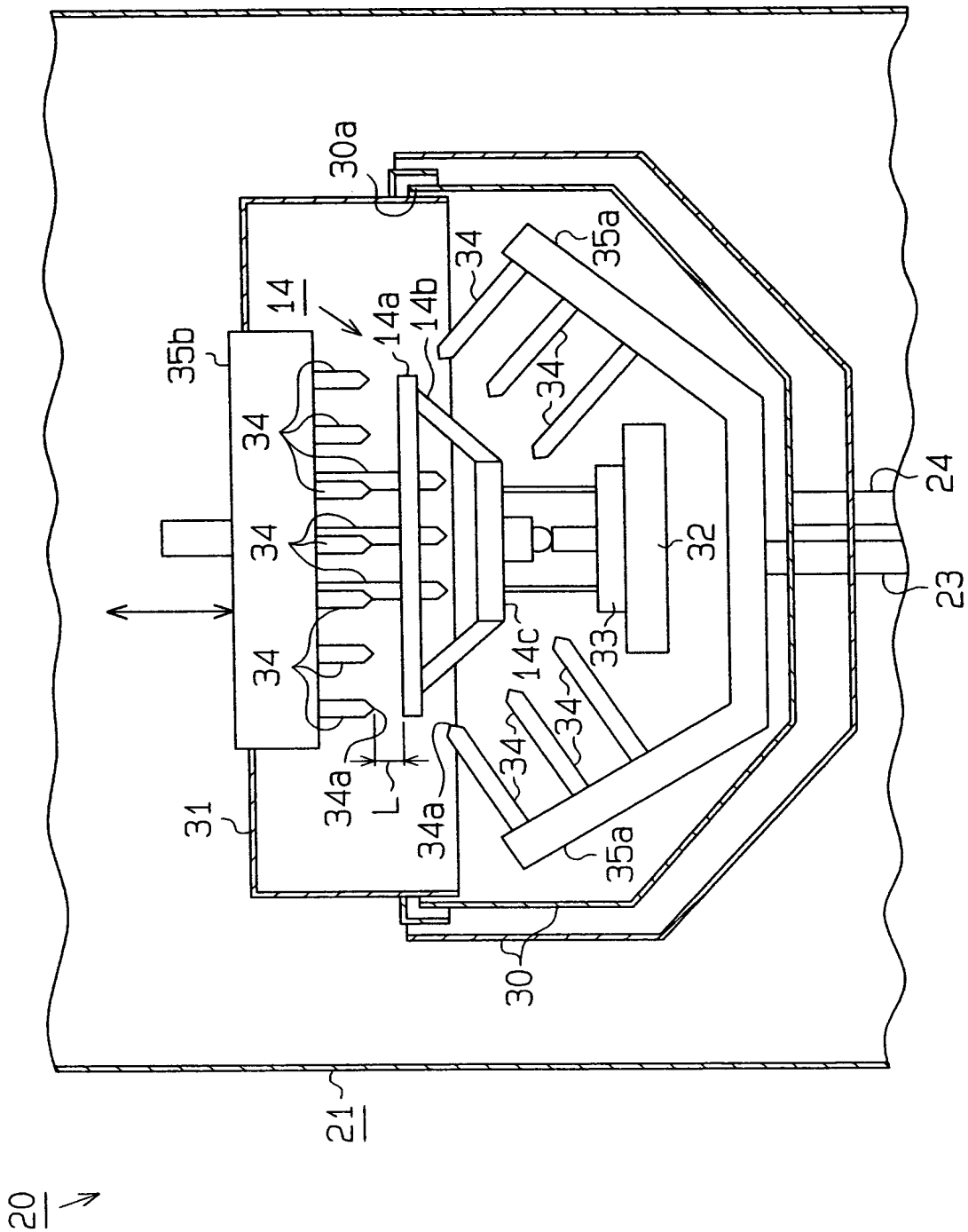


Fig 6

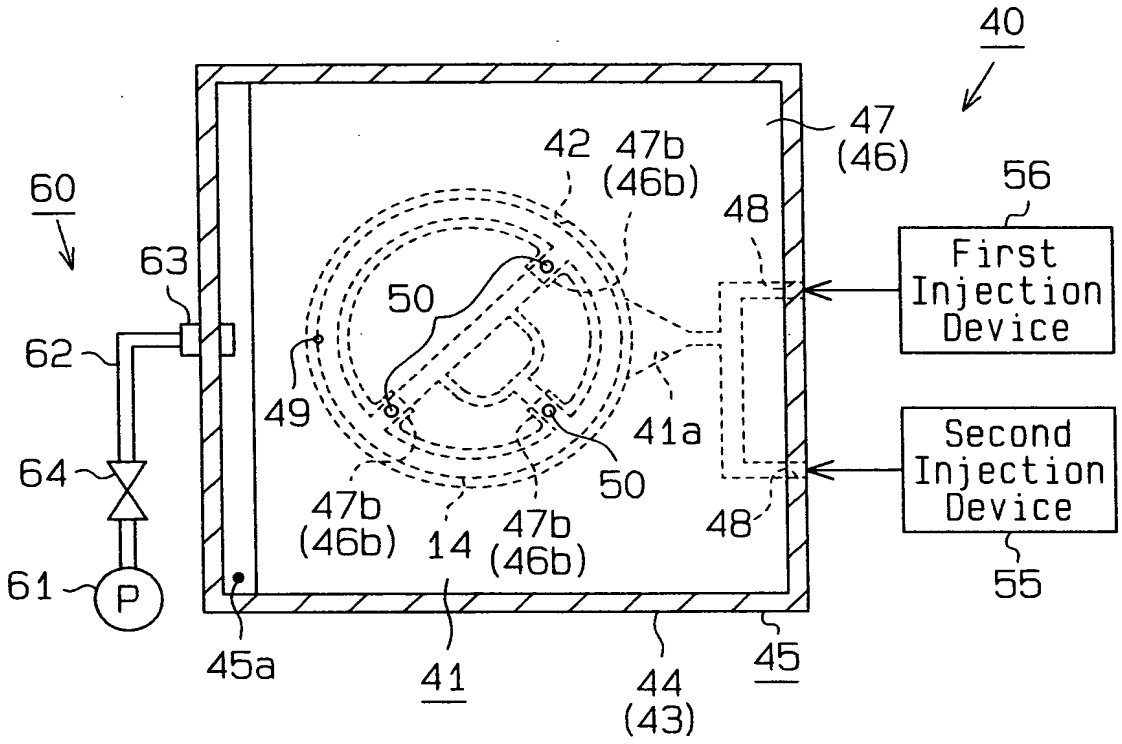

40
47
(46)
42
47b
(46b)
48
56
60
63
First
Injection
Device
50
62
49
41a
64
Second
Injection
Device
50
47b
(46b)
14
47b
(46b)
48
61
P
55
45a
41
44
(43)
45

Fig.7

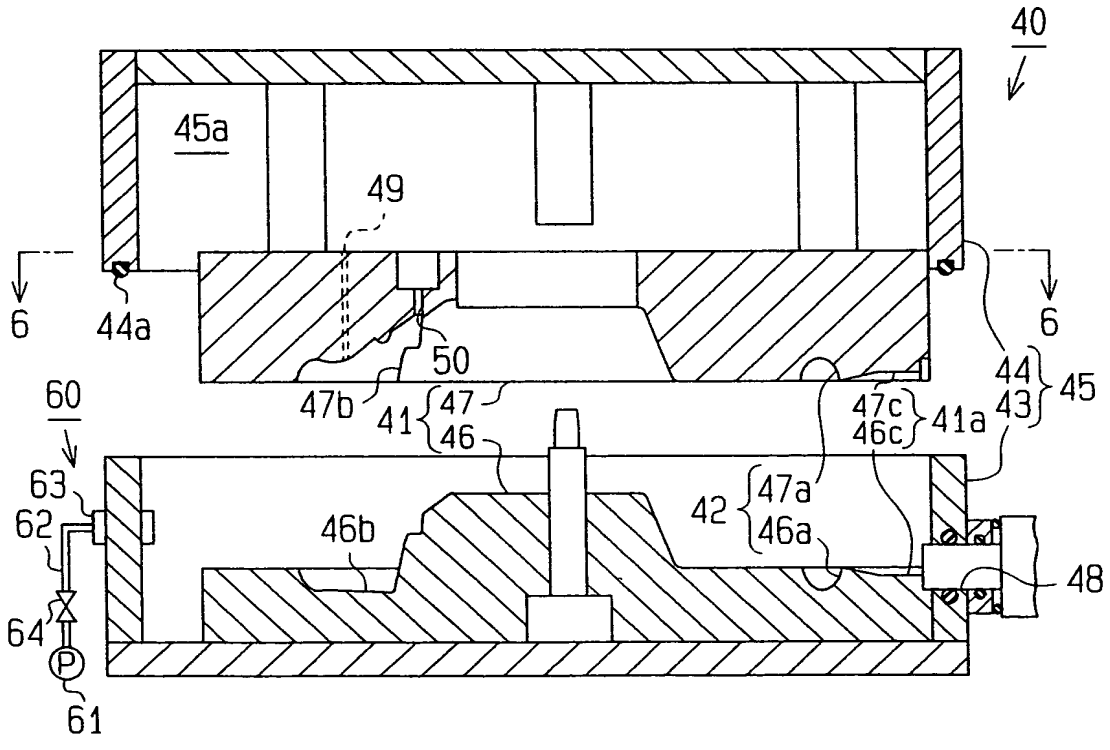
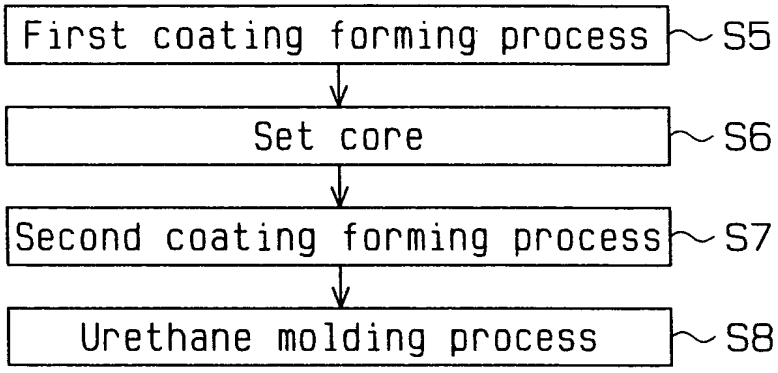

40
45a
49
6
44a
6
50
44
45
47b
41
47
46
47c
46c
41a
43
60
63
62
46b
42
47a
46a
48
64
P
61

Fig.8


First coating forming process
S5
Set core
S6
Second coating forming process
S7
Urethane molding process
S8